

SECTION 1036 -- METAL FLARED-END SECTIONS

1036.01 -- Description

Flared-end sections for corrugated metal pipe shall be zinc-coated (galvanized) steel or aluminum-coated steel.

1036.02 -- Material Characteristics

1. Material used in the manufacturing of flared-end sections shall conform to the applicable requirements of AASHTO M 36 or ASTM A 929.

2. Metal flared-end sections shall be of the design shown on the plans.

3. Bolts, nuts, washers and all other hardware items used with coupling bands shall be galvanized in accordance with AASHTO M 232 (ASTM A 153) or mechanically galvanized in accordance with AASHTO M 298 (ASTM B 695) Class 50.

4. In the repair of damaged coating on flared-end sections which are fabricated by methods which damage their coating, both the interior and exterior surfaces of the damaged area shall be thoroughly cleaned and all traces of welding flux and weld spatter shall be removed. The cleaned area shall then be painted with zinc-rich paint at the fabricating plant, in accordance with Section 1061.

5. The mass of metallic coating may be determined by the use of magnetic thickness gages in accordance with ASTM E 376. In cases of dispute, additional samples shall be tested in accordance with AASHTO T 65 or AASHTO T 213, as applicable.

6. Unless otherwise specified on the plans, the minimum sheet thickness for fabricating metal flared-end sections shall be as follows:

Table 1036.01
Steel and Aluminum Flared-End Thickness

Nominal Diameter Inches (mm)	Sheet Thickness Inches (mm)
12 thru 24 (300-600)	0.057 (1.45)
30 thru 36 (760-900)	0.072 (1.83)
42 thru 84 (1060-2100)	0.101 (2.57)

7. Coupling or connecting bands with projections (often referred to as dimple bands) are not acceptable.

1036.03 -- Acceptance Requirements

Metal flared-end sections will be accepted based on the requirements of this section and sampling and testing requirements as prescribed in the *NDR Materials Sampling Guide*.